Work Order II July-23-12 2:38:35 P			*876	16*						Page 1
Revision ID: Item Name: Float	2-742-011 Skidtube Installation		Accept	*N900		100)* s	Setup Star Stop	1 71	S1* S2*
Start Date: 7/10/ Required Date: 8/31/ Reference:	- •	•		Cust Item II Customer:	D:					
	cess Plan:M_	Date: \2 O	Y Tooling: SPC (Y/N):		nte:		F	Run Star Stop		R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
IIN-D412-742 100 *100* Document Control 110 *110* Packaging Packaging	Pick Kit	T CONTROL Memo Photocopy bluefile and create laborate Memo		14			_ f	J 401	MLJ	12/11/13/
120 *120* QC Quality Control		Inspect kits for completeness Meme	373	4 6	,					

Date: DQA: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: AGAINST DEPARTMENT/PRÔCESS DISPOSITION Work Order: Rework Skid-tube Crosstube Water Jet Engineering Prod. Eng. Coor. Machining Part No. Scrap Small Fab Quality Rec/Store/Packaging Thermoforming Finishing Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Root Initial Action Sign & Verification QC Inspector or Non-conformance Chief Eng Description Date Step Qty Date Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bending Bend Grain Pressure/Forced Ovalized Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Weld Inspection Incomplete Part Incorrect Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

140 QC

Quality Control

Work Order ID July-23-12 2:38:35 PN			*876	316*						Page
Revision ID:	742-011		Accept	*N900	040	100)* s	Setup Star	IV	IS1* IS2*
Start Date: 7/10/1 Required Date: 8/31/1 Reference:	Start Qty: 1.00	*1* *1*		Cust Item II Customer:	D:					
	ess Plan:	Date:	Tooling: SPC (Y/N):		nte:		I	Run Sta Sto	17	IR1* IR2*
Sequence ID/ Work Center ID 130 *130* Packaging	Operation Description Packaging Memo	decode for chinai Tongo and	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. r Stamp
Packaging 140	Location QC21- Final Inspection		0.00					b	-111	H (

0.00

Memo

										DQA:	Date:	
NCR:	Yes / N)			WORK ORDER NON-	CON	NFOR	MANCE / UPDATE				•
					I					QA Closed:	Date:	
Work Ord	٠.,				DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
WORK Orde	er				Rework	٦		Skid-tube Crosstube			Water Jet	Engineering
Part I	Vο				Scrap	1]		Machining Small Fab	-	Proc	d. Eng. Coor.	Quality
					Use-as-is	1		noforming Finishing	-	l	e/Packaging	Other
NCR I	No.				Work Order Update	1		Large Fab Composite	-	•	Supplier	1
						-				· ·		
Root				Descri	ption of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data	Ш											
Equip/Tooling								,				
Operator												
Material												
Setup	<u> </u>							·		·		
Other												
Process												
Supplier	Н											
Training	Н					ł						
Unapproved		<u> </u>		l			T CATE	CORV				<u> </u>
Landi	ng Gear				General	AUL	I CAIL	GONT				
Lariui	Bendir	ıσ		Г	Bend		Grain			Ovalized		Pressure/Forced
	\vdash	ъ Not Conce	ntric to		BOM/Route	-	Hardwa	uro.	\vdash	Over/Under	tolerance	Temperature/Cure
	Cracks			~,~ -	Broken/Damaged	一	ł	ion Incomplete	\vdash	Part incorred	 	Weld
	\vdash	d/Crimped		<u> </u>	Burrs	-	1 '	ions Incomplete/Unclear		Part Lost/Mi		Wrong Stock Pulled
	Cuffs	,	•	<u> </u>	Contamination		Mainte	· ·		Part Moved		7
	Heat T	reat			Countersink		Mislabe			Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

87616

Parent Item:

D412-742-011

Pårent Item Name:

Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/31/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13New IssueKJ/JLM

IPP Rev:B 06-06-08 As per DSI9336 JLM IPP Rev:C 07-05-28 As per Rev C JLM 07.11.01 ecn 1053P EC IPP rev D

07.11.27 ecn 1072 EC verified by:DD IPP rev E IPP Rev:F 08-09-08 ecn 08-510 DD verified by:EC

IPP Rev:G 09-01-23 as per DSI9441 DD verified by:EC DSI9517 REV.B DD verified by:EC IPP rev:I 12.01.12 PER IIN REV.E DD VERF:

IPP Rev:H 11.11.01 as per

Component I Item Name	tem ID/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-041 Tow Ring	5m/>		Manufactured	No			110	Each	6.0000	8	8 212	J B	***	
					Location		Loc Qty	<u>L</u>	oc Code				•	
					ST463		6				<u> </u>			
					854		1							
					866	72	5			2				Δ
D3417-8 Washer 57	Δ	OK	Manufactured	No			110	Each	17.0000	2 8	6 735	JB		54
211	,)				Location		Loc Oty	<u>L</u>	oc Code		•			-
			-		FG		9							
	•				335	19	9	•						
					ST042		8	1						
		_	•		802	25	. 8							
D412-742-041 Replacement F			Manufactured	No			110	Each	0.0000		1	8734	6	¥
D412-742-015		. ,	Manufactured	No			110	Each	2.0000		1953	JB	16	4/1//
Licentoscop	•	(A)			Location		Loc Qty	<u>L</u>	oc Code	•		0	- :	54
					FG121	* ***		2				*		
					845	521		2		·				<i>'</i>

										DQA:	Date:	
NCR:	Yes / I	No			WORK ORDER NON-	COI	VFOR	MANCE / UPDAT	and the second s		Data	
					Y	-			· · · · · · · · · · · · · · · · · · ·	QA Closed:	Date:	
Marie Onde					DISPOSITION			A	AGAINST DEP	PARTMENT	/PROCESS	
Work Orde	er				Rework	7		Skid-tube Cr	rosstube		Water Jet	Engineering
Part N	No.				Scrap	4		· · · · · · · · · · · · · · · · · · ·	mall Fab	Pro	d. Eng. Coor.	Quality
				 	Use-as-is	1		~ 	Finishing		re/Packaging	Other
NCR 1	No				Work Order Update]		Large Fab Co	mposite		Supplier	
			7	1 5 .		T	 :4:-1	A -1:		Cian 0		1
Root			١	1	ption of work order update		Initial	Action		Sign &	Vorification	OCIncustor
Cause	Da	te Step	Qty	•	or Non-conformance	Cr	nief Eng	Descriptio	on I	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator				1								
Material	H											
Setup Other	\vdash											
Process												
Supplier	H											
Training			1									
Unapproved												
					F	AUI	LT CATE	GORY				
Landi	ng Gear				General			,				
	Bend	ing			Bend		Grain			Ovalized		Pressure/Forced
	Cent	re Not Conce	entric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracl	KS _			Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
·	Crus	ned/Crimped	l.		Burrs		Instruct	tions Incomplete/Uncle	ear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs	;			Contamination		Mainte	enance		Part Moved		
	Heat	Treat			Countersink		Mislabe	eled		Positioned V	V rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink Cut Too Short

Drill Holes

Drawing

Finish Folio

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July-23-12 2:38:34 PM

Work Order ID:	87,616										
Parent Item:	D412-742-011								t Date: 7/10/12	Required Date: 8/3	
Parent Item Name:	Float Skidtube Insta	allation						Sta	rt Qty: 1.00	Required Qty: 1.0	
D2570 Saddle, Fwd Out 205	al	Manufactured	No			110	Each	5.0000	89090	JB	34
Sm>				Location		Loc Qty		Loc Code			
				ST		1					r
				11644		1				•	
•				ST425		-13					
•				ST432		4					
				85607		4					
ante.				ST433		13			.		A
D2572 Saddle, Fwd In 205	cK	Manufactured	No			110	Each	5.0000	9/373	- 2B	- 50°
SMA				Location		Loc Oty		Loc Code			
				ST432		5					
				71107		2				•	
				85608		3			1	_	
D2573	,	Manufactured	No			110	Each	1.0000	90213	13	
Saddle, Aft Out 205	cit										
SHO				Location		Loc Oty		Loc Code			
01-1-				ST423		-12					
				79424		. 0					· ·
				ST433 83669		1					_ (1)
				ST434		12					
Barray.	,		No	31434		. 110	Each	1.0000	1		
D2574. Saddle, Aft In 205	cK	Manufactured	No				Lacii		89900	g B	12/14/3
Sh				Location		Loc Qty		Loc Code			
				ST433	· · · · · · .	. 1					
				83671		1				•	: 2

NCR:	Yes	/ No					WORK ORDER NON-C	:O1	NFORM	MANCE / UPDATE				
					·	_					QA C	losed:	Date:	
Vork Ord	er:						DISPOSITION			AGAINST D	EPART	MENT	PROCESS	
Part I	No.						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	Re		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Des	crip	otion of work order update	ı	nitial	Action	Sig	n &		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Description	D	ate	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved														
							F	AUL	T CATE	GORY				
Landi	ng (Gear					General		•	_	_		_	· .
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea	Crimped.		O/S		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		4	ion Incomplete tions Incomplete/Unclear enance	Part Part Part		issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Inspection	n Strip in	Tube			Cut Too Short		Misread	j .	Pow	er Loss/	'Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n ·		Drawing		Out of 0	Calibration				
		Turning So	equence				Finish		Out of	Sequence				

Outside Dimensions

DQA:

Date:

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Wave/Twist in Tube

Folio

July-23-12 2:38:34 PM

Work Order ID:	87616					٠				
Parent Item:	D412-742-011						Start Dat	te: 7/10/12	Required Date	: 8/31/12
Parent Item Name:	Float Skidtube Ins	stallation					Start Qt	y: 1.00	Required Qty	: 1.00
D2876 Saddle Spacer	,	Manufactured	No		110	Each	119.0000	2 8.82	82 JB	
	d			<u>Location</u>	Loc Qty		Loc Code		•	<u> </u>
< mR				ST020	74					
SM>				83323	40					
				83890	34					
				ST022	45				_	
				86734	25				_	
	,			87292	20				_	all.
2877 addle Spacer	cx	Manufactured	No		110	Each	140.0000	2	2 JB	
				Location	Loc Qty		Loc Code			
Sno				ST020	140					
J/42				83324	2					
		•		83891	42					
				86442	40			8689	3/	I
	,			86890	56	- 1	40,0000			Al l
3403=0 Jushing	CK	Manufactured	No		110	Each	49.0000	8 887	82 JB	
				Location	Loc Oty		Loc Code			
SMS				ST041	15				<u>. </u>	
J				70696	15					* * *
				ST042	34		•,			_
				80208	7					\sim \sim Ω
				80219	. 4					
	•			85661	23		•			
D3403-5 Bushing	CIL	Manufactured	No		110	Each	29.0000	8 8 8	184 yb	12/11/1
				<u>Location</u>	Loc Oty		Loc Code		and the second	
SMO				ST042	29				<u>. </u>	
-,,,				85664	29			***		

											DQA:	Date:	* •
NCR:	Yes	/ No				WORK ORDER NON-	100	NFOR	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	ar.					DISPOSITION	:			AGAINST DE	PARTMENT	/PROCESS	·
	=1.					Rework	1 l		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	Nο					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, ,,,,,						Use-as-is	1		noforming	Finishing	-	re/Packaging	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite		Supplier	
						,	_				-		
Root					Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			İ										
Operator .													
Material			ļ						-				
Setup									•				
Other													
Process													
Supplier									·				
Training		-									1	1	
Unapproved				l									
						F	AUL	T CATE	GORY				
Landi	ng (Gear				General		•					_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Picklist Print

July-23-12 2:38:34 PM

Page 4

Work Order ID: Parent Item: Parent Item Name:	87616 D412-742-011 Float Skidtube Insta	allation						Date: 7/10/12		Required Date: Required Qty:	. / /
D2747 Set Screw	ck	Manufactured	No		110	Each	456.0000	A	4	- gB	5
				Location	Loc Qty		Loc Code			-	
SMS				ST017	256	;					* .
				79520	:	i			***		
				81877	5			727.3			
				86439	200)		864	<i>3</i> 7		
				ST019	200)					\sim
				86827	200)					<i>i</i>
D3533:1 Set Screw	CIL	Manufactured	No		110	Each	148.0000	2	2	~ 1B	
_				Location	Loc Qty		Loc Code			/	
Sm)				ST053	4	3					
				80326	:	2					
				83892	4	5					^
				ST058	10)					
_				87348	10)	•		348		
AN4C6A Bolt	cx	Purchased	No		110	Each	367.0000	100	1900) _ 18	
	•			Location	Loc Oty		Loc Code			V	
\sim		•		FG		4					
Smo				103344		4					
				ST356	36	3				•	^
				116704		2					
•			,	120423		1					
				121657	36					. •	
AN4G52A BOLT	CF	Purchased	No		110	Each	6.0000	122	784	3 JB	12/11/
5m				Location	Loc Qty		Loc Code				
— , . ,				ST361	•	6					
				117688		6					

										DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-C	O	VFOR	MANCE / UPDATE				
										QA Closed:	Date:	
Work Orde	er:				DISPOSITION	•		AG	AINST DE	PARTMENT	PROCESS	
Part f					Rework Scrap Use-as-is Work Order Update		1	Machining Sma	sstube all Fab ishing posite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	1	nitial	Action		Sign &	·	
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator						1						
Material												
Setup												
Other												
Process												
Supplier				:								
Training			,	;								
Unapproved												
					F,	AUL	T CATE	GORY				
Landi	ng Gear				General							_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	lot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	et .	Weld
	Crushed	/Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		•
	Heat Tre	at			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Picklist Print

July-23-12 2:38:34 PM

Page 5

Work Order ID:	87616									
Parent Item:	D412-742-011				* .		Start	Date: 7/10/12	Required	l Date: 8/31/12
Parent Item Name:	Float Skidtube Insta	allation					Star	t Qty: 1.00	Require	d Qty: 1.00
ANGESIA Bolt	(1/4	Purchased	No		110	Each	97.0000	A	4 /	, 5
SM)			Location	Loc Oty		Loc Code			——————————————————————————————————————
				ST361	97					
				122193	97			1921	93	á /)
AN6CI2A BOLT	at	Purchased	No		110	Each	32.0000	8 122	708	0 5
				Location	Loc Qty		Loc Code		·	
5m-				ST341	32					
				121541	7					· 1]
		·		122204	25					劃/
D3672-3 Phenolic Washer	CK	Manufactured	No		110	Each	1,211.0000	32 9/	9/5	20 S
				Location	Loc Qty		Loc Code		,	•
SM>				ST060	1211					
				84361	211					Λ
		./		84432	500					/· h
	cuve a HzaR	c1 ²		86517	500					
	51149 CO\$ 32R	Purchased	No		110	Each	0.0000	78 X 13	32	00
WASHER			3.7.		. 110	Each	292.0000	1471	19124	
D3672-9		Manufactured	No		110	Each	292.0000		8 -	3 12///
Phenolic Washer) cx			Location	Loc Qty		Loc Code			7-1-1-
•	<i>O</i> .	•		ST060	292	,	<u> Loc Couc</u>			
				81763	292			817	63	
				01705		-				

		,	
NCR:	Yes	/	No

DQA:

Date: __

NCR:	Yes	/ No					WORK ORDER NON-C		NFORM	//ANCE / UP	DATE			
												QA Closed:	Date	
Nork Ord	or.						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	·
, von Cra	٠,,					1	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.						Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						ı	Use-as-is		Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	Vo.			<u> </u>	 		Work Order Update]		Large Fab	Composite]	Supplier	
Root					Desci	ript	tion of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data														
quip/Tooling														
perator														
laterial														
etup	_													
ther														
rocess														
upplier	H													
raining		!												
napproved	<u> </u>		L.,	L	<u>L</u>		F	<u>ι</u> Δ111	T CATE	SORV				
Landi	ng (General		- CAIL	<u> </u>			-	
		Bending			Г	\neg	Bend	Г	Grain			Ovalized		Pressure/Forced
	_	Centre No	t Concer	ntric to	o/s	—	BOM/Route	<u> </u>	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				_	Broken/Damaged		Inspecti	on Incomplete	•	Part Incorre	-	Weld
	Г	Crushed/0	Crimped.			_	Burrs		•	ions Incomplete/	/Unclear	Part Lost/M	ssing	Wrong Stock Pulled
		Cuffs				٦	Contamination		Mainte	nance		Part Moved	_	
		Heat Trea	t		<u> </u>	٦	Countersink	\Box	Mislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube		\Box	Cut Too Short		Misread	í		Power Loss/	Surge	Other
		Ripples in	Bend			<u></u>	Drill Holes		Offset		_	<u> </u>		
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration				
		Turning S	equence			_]r	Finish		Out of S	Sequence				
		Wave/Tw	ist in Tub	oe .	F		Folio		Outside	Dimensions				

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July-23-12 2:38:34 PM

Work Order ID:	87616											
Parent Item:	D412-742-011							Start	Date: 7/10/12		Required Date	: 8/31/12
Parent Item Name:	Float Skidtube Insta	allation						Star	t Qty: 1.00		Required Qty	2: 1.00
NAS1149G0632R WASHER	ck	Purchased	No			110	Each	367.0000	8	8	90	5
. 1				Location		Loc Qty		Loc Code				
5m3				296		200				·.		
_					122441	200			<u></u>			.
				ST297		167						\wedge
					119736	2						~ ./ <u>~</u>
					120308	1			1213	2 25		
					121825	164	ъ .	107 0000	8	0		
D3672-11 Phenolic Washer	cl	Manufactured	No			110	Each	187.0000	14917	(6 8	JB.	2
_ ^				Location	<u>!</u>	Loc Oty		Loc Code				
Sms				ST060		187			. 	/		6
					77483	187			7 × 174	83		
MIS21043=4 Nut	CF	Purchased	No			110	Each	2,069.0000	B	29	V JB	
				Location	<u>1</u>	Loc Qty		Loc Code			V	
Sms				315	_	600						12,
SMC					122452	600					•	
				FG		40						100
					104603	40						
				ST301		429						
,					119546	4						• • •
					121162	46						•
		٠			121652	379						#
				ST318		1000			- ; 2. 0	1411		
y.					122141	1000			122	141		760
AN4G7A Bolt		Purchased	No			110	Each	115.0000	122	8434	20	12/11/1
SM-				Locatio	<u>.</u>	Loc Oty		Loc Code			•	
. •				ST356		115	i					
					109147	115						4.1

												DQA:	Date	e:	
NCR:	Yes	/ No				WORK ORDER NON-	100	VFORM	MANCE / UP	DATE		•		_	
y												QA Closed:	Date	e:	
Work Ord	or.					DISPOSITION				AGAINST	DE	PARTMENT/	PROCESS		
Work Ord	C1.			· · · ·		Rework	7		Skid-tube	Crosstube]	Water Jet	\neg	Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab		Proc	d. Eng. Coor.		Quality
		,				Use-as-is]		noforming	Finishing	—	Rec/Stor	e/Packaging		Other
NCR	No.					Work Order Update]		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &		П	
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	cription		Date	Verification	1	QC Inspector
Doc/Data															
Equip/Tooling			l												
Operator														Ì	
Material														ļ	•
Setup														Ì	
Other															
Process							1								
Supplier		•													-
Training															
Unapproved															
						F	AUI	LT CATE	GORY						
Landi	ng (Gear				General		-				7	-		ı
	<u></u>	Bending				Bend	L	Grain			L	Ovalized	1		Pressure/Forced
	<u></u>	Centre N	ot Concer	ntric to	O/S	BOM/Route		Hardwa	ire		L	Over/Under	F		Temperature/Cure
		Cracks				Broken/Damaged	L	Inspect	ion Incomplete			Part Incorre	ct [Weld
Ì		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

July-23-12 2:38:34 PM

	Work*Order ID:	87616								t Date: 7/10/12	Required Date: 8	/21/12
	Parent Item:	D412-742-011								rt Qty: 1.00	Required Qty: 1	_
	Parent Item Name:	Float Skidtube Insta	llation								Required Qty. 1	.00
	D3591-1 Bushing	/	Manufactured	No			110	Each	77.0000	92873	JB_	. 57
	/ W/K	7,			Location		Loc Qty		Loc Code			
		-JU /			FP		5					
	\l.	19 /y			80377		4					
	200	on James			82027		1					
		Drail			ST055		72					
		$\mathcal{L}^{\mathcal{L}}$			57350		1					
200					83237		71					
Œ	D3403-3 Bushing	cX	Manufactured	No			110	Each	36.0000	L8 18783	30	
	5m3				Location		Loc Qty		Loc Code		٠.	
	2/110				ST042		36					
					85662		36					
	103405-041 Lug Assembly	UZ	Manufactured	No			110	Each	22.0000	F1 89218	- g.B	
	*	-			Location		Loc Oty		Loc Code	,	·	
	Shes				ST478		4					. *
	٥١١٠				62227		2					
					77000		2					\cap
					ST748		18					AM
	•	,			85098		18					
4	D3405-043 Lug Assembly	UC.	Manufactured	No			110	Each	19:0000	9005	7 gB	12/11/13
	_				Location		Loc Oty		Loc Code			
	$Sn\Delta$		•		ST478		19)				
					82038	1	1					
					84941		. 18	3			÷	•

										DQA:	Date:	ر و
NCR:	Yes / No				WORK ORDER NON-O	CON	IFORN	MANCE / UPDATE		QA Closed:	Date:	
					DISPOSITION			AGAINST		PARTMENT/		
Work Ord	er:				_ ,_	, I					Water Jet	
Do mt 1	\\				Rework	-		Skid-tube Crosstube Machining Small Fab	-	Dro	d. Eng. Coor.	Engineering Quality
Part i	NO				Scrap Use-as-is	1		noforming Finishing			e/Packaging	Other
NCR I	No				Work Order Update	j		Large Fab Composite		1100	Supplier	
Root				Descri	ption of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												·
Setup						'						
Other												
Process	<u> </u>											
Supplier	Щ											
Training												
Unapproved			<u> </u>	<u> </u>			T 04TE				İ	1
						AUL	T CATE	GUKY				
Landi	ng Gear			_	General		Grain		Γ	Ovalized		Pressure/Forced
	Bending			~ 	Bend BOM/Route	\vdash		,	\vdash	1	talaransa	Temperature/Cure
	—	Not Conce	entric to	^{0/8} -	BOM/Route	Н	Hardwa		\vdash	Over/Under	<u> </u>	Weld
	Cracks	1 /C=:			Broken/Damaged	Н	-	ion Incomplete	\vdash	Part Incorred Part Lost/Mi		Wrong Stock Pulled
	Cuffs	I/Crimped	l_	<u> </u>	Burrs Contamination	H	Mainte	cions Incomplete/Unclear	\vdash	Part Moved	· ·	I who like a rock rulled
	Heat Tr	nat		<u> </u>	Countersink	\vdash	Mislabe		-	Positioned V		
!	l lucarii	cal			Countersing		liviisiabe	ieu .	1	prositioned v	VIOLIS	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

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July-23-12 2:38:35 PM

Work Order ID:	87616									
Parent Item:	D412-742-011							Date: 7/10/12	Required Date:	
Parent Item Name:	Float Skidtube Inst	tallation			•		Start	t Qty: 1.00	Required Qty:	1.00
AN4G47A Bolt		Purchased	No		110	Each	70.0000	1228	13 JB	S
				Location	Loc Qty		Loc Code		V	
<~^				ST359	38				_	
3111/				112491	38				_	
				ST361	32				_	
				118451	6					
				119798	2				_	
				121009	22				_	
1				121585	2					A
103456-11 Washer		Manufactured	No		110	Each	169.0000		1 78	
5n0				Location	Loc Qty		Loc Code			
2 M				FG	7					
				25701	7				_	
				ST044	162					\wedge
				80252	1			-	_	A A
				83584	69					al l
				85223	92			8522	13	
AN3G37A BOLT	ch	Purchased	No		110	Each	110.0000	3	3 / J.B	12/11
SMS			·	Location	Loc Qty		Loc Code			
				ST324	50					
		•		122204	50			12220	4	
				ST354	60				-	
				116874	11				-	
				117010	. 2					
•				120422	3					
				121584	. 2				_	
				121585	42					

		DQA:	Date:	* * * * * * * * * * * * * * * * * * *
ICR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	•					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	lr	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator													
Material					2				1				
Setup													
Other													
Process	Ш						Ì						
Supplier	Ш												
Training	Ш								-				
Unapproved											<u> </u>		
							AUL.	T CATE	GORY				
Landi		I				General				F	٦	_	- 1
	$\overline{}$	Bending			<u> </u>	Bend	-	Grain		<u> </u>	Ovalized	Ŀ	Pressure/Forced
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa		_	Over/Under	 	Temperature/Cure
	-	Cracks			_	Broken/Damaged		•	on Incomplete	_	Part Incorre	}	Weld
	\vdash	Crushed/	Crimped.		<u> </u>	Burrs			ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	-	Cuffs			<u> </u>	Contamination	-		enance	_	Part Moved		
	-	Heat Trea			<u></u>	Countersink	-	Mislabe			Positioned V	_	-
	\vdash	Inspection		Tube	_	Cut Too Short		Misread	d		Power Loss/	'Surge	Other
Ripples in Bend Drill Holes				4	-	Offset							
	Ш	Torque W			1 <u> </u>	Drawing	-		Calibration				
	Ш	Turning S	equence			Finish		Out of	Sequence				
		Wave/Tw	ist in Tub	эe	- 1	Folio		Outside	Dimensions				

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Picklist Print

July-23-12 2:38:35 PM

Parent Item: D412-742-011					C	D 4 - 7/10/12	Damiliand Datas 9/2	1/12
						Date: 7/10/12	Required Date: 8/3	/ /
Parent Item Name: Float Skidtube Installation						et Qty: 1.00	Required Qty: 1.0	
AN3G40A Purc	hased No		110	Each	18.0000	122813	~ g B	
5m		Location	Loc Qty		Loc Code		V	
		ST354	18					
		114442	18					الما
5000	hased No		110	Each	209.0000	122843	18	
·		Location	Loc Oty		Loc Code			V
≤m>		FG	4					
		103324	4					**
		ST354	205					4
		121013	24			***		
		121313	80					
		121689	1					
AN3G42A Pure	chased No	122241	100 110	Each	65.0000	3	V	
BOLT OF PURC	museu						Jo	
		Location	Loc Qty		Loc Code			
SHO		ST354	65					
		106176	1					/).
•		120464	1				* * * * * * * * * * * * * * * * * * * *	
		121103 122241	13 50			122241		75
200000	chased No	122241	110	Each	53.0000	3 100 = 13	,	
BOLT Pure	chased No		110	Eacii	33.0000	122843	30	12/11/13
		Location	Loc Qty		Loc Code		·.	- 1
5m3		ST354	. 53		*			
		114455	2			· ·		
		119673	1					1
		120465	50					ž.

			•	
DQA:	Date:	 ~3	_	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date:	· .
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update	∃	ermoforming Large Fab	FinishingComposite	Rec/Stoi	re/Packaging Supplier	Other
Root		1		Descr	ription of work order update	Initia	ıl /	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ing De	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling									·		
Operator											
Material										·	
Setup Other											
Process											
Supplier	\dashv										
Training					•						
Unapproved							1				
				I	<u>, , , , , , , , , , , , , , , , , , , </u>	FAULT CA	ATEGORY				
Landin	ng Gear				General						
	Bending				Bend	Gra	in		Ovalized		Pressure/Forced
[Centre N	ot Conce	ntric to	o/s	BOM/Route	Har	dware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Inst	ructions Incomplet	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	intenance		Part Moved		
	Heat Trea	at		_	Countersink	Mis	labeled		Positioned V	Wrong	-
1	Inspectio	n Strip in	Tube		Cut Too Short	Mis	read		Power Loss/	Surge	Other
	Ripples ir			•	Drill Holes	Offs					
	Torque W			n _	Drawing		of Calibration				
	Turning S				Finish	Out	of Sequence		· · · · · · · · · · · · · · · · · · ·		
l	Wave/Tw	vist in Tul	ре		Folio	Out	side Dimensions				

Picklist Print

July-23-12 2:38:35 PM

Work ^o Order ID: Parènt Item:	87616 D412-742-011						Star	rt Date: 7/10/12	Required Date:	8/31/12	
Parent Item Name:	Float Skidtube Insta	allation						Start Qty: 1.00		Required Qty: 1.00	
AN3C44A BOLT	ck	Purchased	No		110	Each	35.0000	122843	" J.B	3	
\sim				Location	Loc (<u>Oty</u>	Loc Code		,	\bigcap	
SM3				ST354		35		<u> </u>			
AN3C37A BÖLT	et	Purchased	No	110848	110	35 Each	16.0000	123116	× 28	_\$	
Sms				Location	Loc C	<u>Otv</u>	Loc Code		,		
3 /**	(/			ST355		16					
	ik			116874		16	21 0000				
AN960G10L washer	NAS1149C0332R	Purchased	No		110	Each	21.0000	66' /23325	18		
Smo				<u>Location</u>	Loc	Qt <u>y</u>	Loc Code		7		
7.0				ST		21					
	cK		NI-	107534	100	21 Each	934.0000	33 7 33	/		
MS21043-3 Nut	V.	Purchased	No		100	Each	934.0000	12352	5 28	12/11/1	
5m2				<u>Location</u>	Loc	<u>Oty</u>	Loc Code		0	, , , , ,	
				FG 103691		72 72					
				ST301		862					
				118077		2					
				118614		12					
				118686		30			* .		
				119758		20					
				121255		22: 776					
		•		121708		776					

		1 ³ 2.		
DQA:	Date:		3	•

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

							i e			QA Closed:	Date	e: '
Work Orde	Jork Order: DISPOS								AGAINST DE	PARTMENT	;	
Part No.					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality
NCR No.					Use-as-is Work Order Update]	Thermoforming Finishing Large Fab Composite			Rec/Stor	Supplier_	Other
Root				Description of work order update			Initial Action			Sign &		
Cause	Date	Step	Qty	or Non-conformance		Chie	nief Eng Description		cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training												
Unapproved												
						FAULT	CATE	GORY			•	
Landin	g Gear				General							
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs			o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Ovalized Pressure/Forced Over/Under tolerance Temperature/Cu Part Incorrect Weld Part Lost/Missing Wrong Stock Pul Part Moved		
	Heat Treat Inspection Strip in Tube				Countersink Cut Too Short		Mislabeled Misread			Positioned Wrong Power Loss/Surge Other		
	Ripples in Bend				Drill Holes		Offset					
	Torque W	Vaves in E	xtrusion	1 [Drawing		Out of Calibration					
	Turning S	equence					Out of Sequence					
Γ	Ways/Twist in Tuba				Teolio		Outrido Dimonrians					